D205.633011

Work Order ID 61533

Monday, August 30, 2010 10:19:46 AM

Item ID: D2563 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 8/30/2010 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 9/6/2010 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** 10-8-30 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2563	Rev C								
100	Large Fab	0.00							
Large Fab	**Memo**	0.00				4			
Large Fab	1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 ✓	10·09·23							
	2-Deburr ends ✓								
	3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343								
	4- Grind								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00				(4)		10.09.23	
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

Dart Aerospace Ltd

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg A/R Aluminum rod Batch: M112260	0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00	10·09·27			4			
	1-Inspect for foreign object per QSI 024								
	2-Weld Remainig End cap as per Dwg D2563 using DT 8343								
	3-Grind								
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00				11	10.09.27		
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00	10/09/27			4			
Quality Control									

Dart Aerospace Ltd

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				4	ø		
Powdercoat									
Powder Coating	**Memo**	0.00							
	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	M115291 START TIME: 1:00 OVEN TEMPERATURE: 3200 FINISH TIME: 1:30								
190	Wing Walk as per dwg QSI005 4.4 Batch M115028	0.00				4	ø		
HandFinish									
Hand Finishing	**Memo**	0.00							
200	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	**Memo**	0.00							

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location:_____	0.00							
Packaging	Memo PPP 61534	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/30

10/10/01

MF 10-9-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, August 30, 2010 10:19:50 AM

Work Order ID: 61533

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 8/30/2010 **Required Date:** 9/6/2010

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No			100	Each	121.0000	1	4	10·09·22		
Step Extrusion													
				Location			**Loc Qty**		**Loc Code**				
				WA			121						
					57850		35			3			
					60307		86			1			
D2561		Manufactured	No			100	Each	3.0000	2	8	10·09·22		
Lug													
				Location			**Loc Qty**		**Loc Code**				
				WA	60096		3			5			
					59685		3			3			
D2564		Manufactured	No			100	Each	27.0000	2	8	10·09·22		
Mounting Angle													
				Location			**Loc Qty**		**Loc Code**				
				WA			27						
					59686		7			7			
					60097		20			1			
D2673-34		Manufactured	No			100	Each	178.0000	1	4	10·09·22		
End Plate													
				Location			**Loc Qty**		**Loc Code**				
				WA			178						
					57527		1						
					59690		177			4			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, August 30, 2010 10:19:50 AM

Work Order ID: 61533

Parent Item: D2563

Parent Item Name: Step Weldment Assembly

Start Date: 8/30/2010 **Required Date:** 9/6/2010

Start Qty: 4.00 **Required Qty:** 4.00

D2673-34 End Plate	Manufactured	No	150	Each	178.0000	1	4	10.09.22

Location	Loc Qty	Loc Code	
WA	178		
57527	1		
59690	177		4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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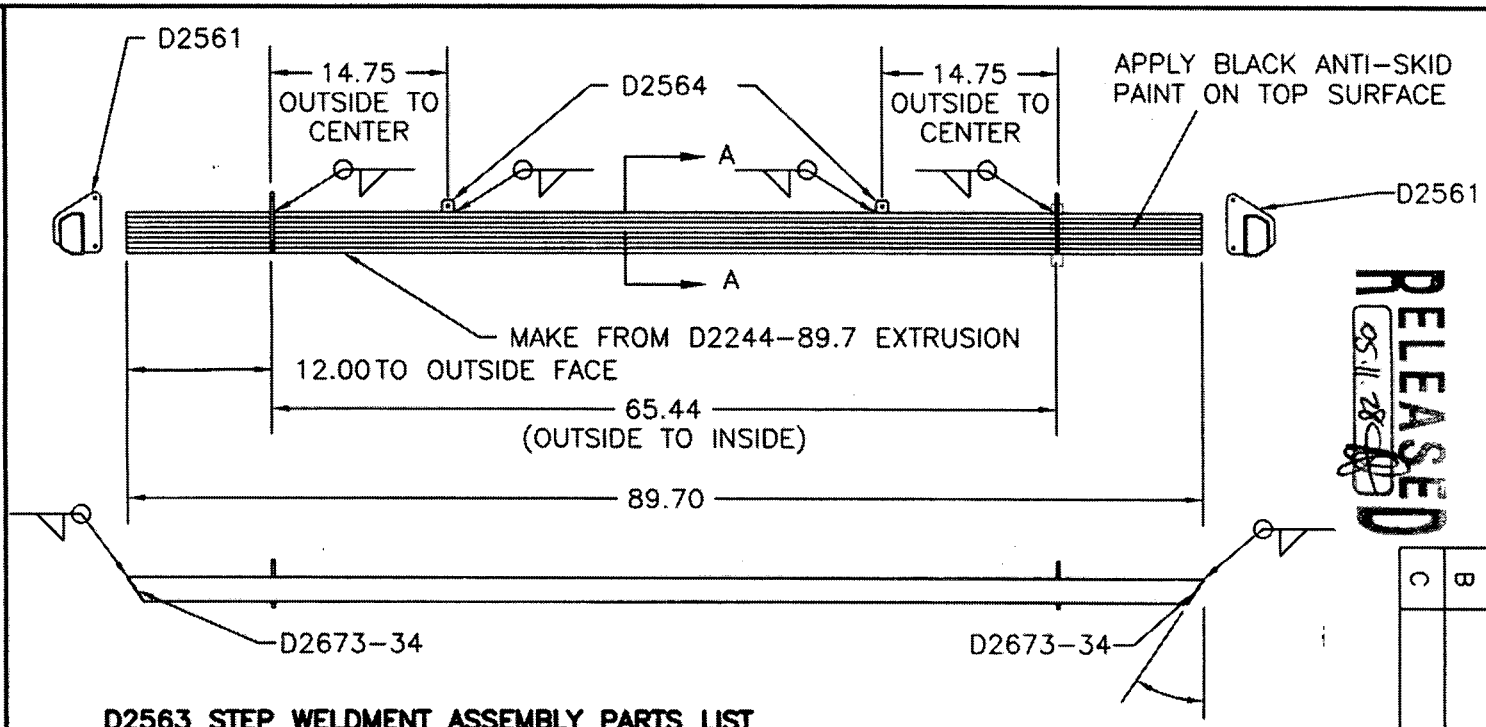
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

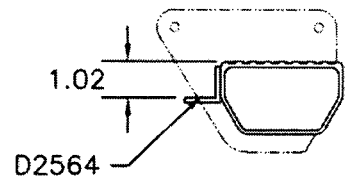


RELEASED 05.11.28

D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



SECTION A–A

D2563 STEP WELDMENT ASSEMBLY NOTES

1) MAKE FROM EXTRUSION D2244
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
   APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61533
96-8-30

A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	SHOP C RETURN TO

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
BW		D2563	C
CHECKED	APPROVED	SHEET 1 OF 1	
DATE 05.11.14		TITLE STEP WELDMENT ASSEMBLY	SCALE 1:15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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